Work Order ID 110158

December-17-13 9:16:56 AM

110158

Item ID: D2012-105
Revision ID:
Item Name: Arm (31.06)

Start Date: 12/17/13 **Start Qty:** 6.00 *6*
Required Date: 12/17/13 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-12-18
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2012-105	**Revision Nbr** E								
100 *100* Brake NC Brake NC	NC BRAKE **Memo** Punch to length as per Dwg D2012-105 & template D2012-105T1	0.00 0.00				6			FF 14-04-04
110 *110* Small Fab Small Fab	Small Fab **Memo** 1-Deburr	0.00 0.00				6			FF 14-04-04
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				6			

DAS 27 9-89 M/4/7

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M126878 **Memo** START TIME: 8.55 OVEN TEMPERATURE: 320° FINISH TIME: 9.25.	0.00 0.00				6	ϕ	14-9.	DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00 DAS 27 9-89 14/4/9				6			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST221 **Memo**	0.00 0.00				6			DAS 33 9-89 14-04-09

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Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00				MCS	14-04-11		
160									
QC	**Memo**	0.00							
Quality Control									

MF 14-4-10

Picklist Print

December-17-13 9:16:55 AM

Work Order ID: 110158
Parent Item: D2012-105
Parent Item Name: Arm (31.06)
Comments: IPP Rev:I02.04.03Added Inspect level 3NG

Start Date: 12/17/13 **Required Date:** 12/17/13
Start Qty: 6.00 **Required Qty:** 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	263.4058	**2.6254**	**16.581473**			FF 14-04-04

Location	Loc Qty	Loc Code	
MAT017	263.4058225		
118702	0.00003		
123303	138.9645		
125513	72.9014525		5.5271
m126922	51.53984		
128084			8.2907

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

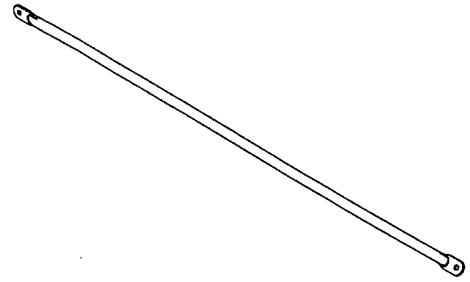
FAULT CATEGORY

Landing Gear

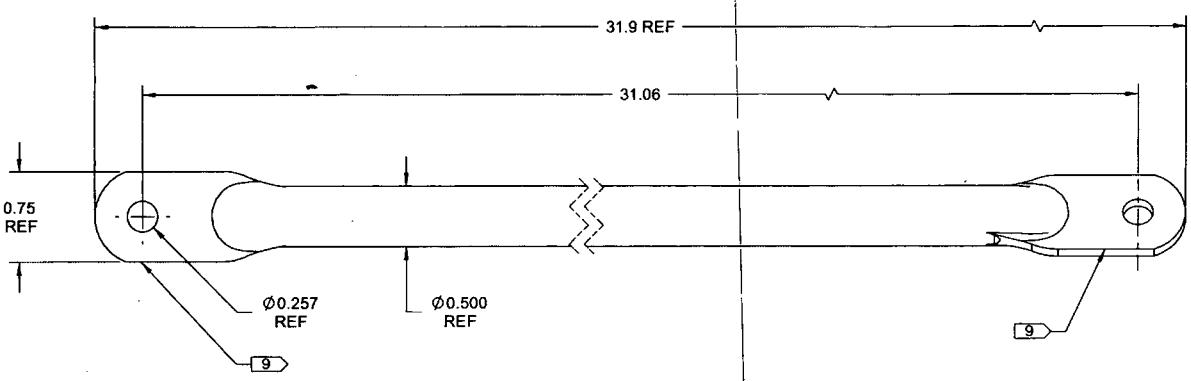
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

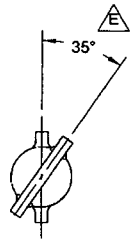
General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other



110158 MLS
13-12-18





RELEASED 09/16/25 MP

D2012-105 ARM

NOTES:
1) MATERIAL: AISI 304/316 SS TUBE Ø0.500 X 0.035 WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
7) WEIGHT: 0.47 lbs
8) MAKE PER TEMPLATE DT8116
9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-060	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2012-105 REV. E
CHECKED		SHEET 1 OF 1
MFG. APPR.		TITLE ARM SCALE NTS
APPROVED		
DE APPR.		
DATE	09.06.04	

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DART AEROSPACE LTD

Description: ARM Work Order: 110158

Inspection Drawing: D2012-105 Rev: E Part Number: D2012-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.9	± 0.030	31.9	✓		SFab-07	
31.06	± 0.030	31.06	✓		SFab-07	

Measured by:	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
FF			
Date 14-04-04	Date 14/04/07	Date 14/4/7	Date